

Work Order ID 156781

Wednesday, February 08, 2017 9:09:40 AM

156781

Page 1

Item ID: D3262-5

Revision ID:

Item Name: Cap

Start Date: 1/30/2017

Required Date: 2/8/2017

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Qty: 500

5

Cust Item ID:

Req'd Qty: 500

5

Customer:

Approvals: Process Plan:

DAS
21
9-89

Date:

FEB 08 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3262

F

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut blanks: 6.000" x 0.500" x 5.400" long Bar

DAS
44
9-89

8

Ø

17-02-28

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

Machine as per dwg D3262

Machine as per Folio FA902 and Dwg D3262

FOLIO REV: EDWG REV: F

TAP USING JIG DT9636

Deburr

DAS
44
9-89

8

Ø

17-02-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 156781

Wednesday, February 08, 2017 9:09:40 AM

156781

Page 2

Item ID: D3262-5

Revision ID:

Item Name: Cap

Start Date: 1/30/2017

Required Date: 2/8/2017

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Qty: 5.00

5

Cust Item ID:

Req'd Qty: 5.00

5

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

8

9

DAS
44
9-89 17-02-26

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

Memo

0.00

8

9

DAS
49
9-89 17/02/27

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Packaging

Memo

LOCATION: WA003

0.00

8

FEB 28 2017

DAS
66
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
3AC AA 20-8							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Work Order ID 156781

Wednesday, February 08, 2017 9:09:40 AM

156781

Page 3

Item ID: D3262-5

Revision ID:

Item Name: Cap

Start Date: 1/30/2017

Required Date: 2/8/2017

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Start Qty: 5.00

Req'd Qty: 5.00

5***5***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC21 - Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
21
9-89

FEB 28 2017

17/2/28 J

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																											
Description Work Order Deviation				Disposition				Completed By																																																										
								Lead hand / Supervisor Approval Verification																																																										
								QC / QA Coordinator Approval																																																										
Root Cause		FAULT CATEGORY																																																																
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	Past Due ☐																																																																	

Picklist Print

Wednesday, February 08, 2017 9:09:40 AM

Page 1

Work Order ID: 156781

Parent Item: D3262-5

Parent Item Name: Cap

156781
D3262-5

Start Date: 1/30/2017

Required Date: 2/8/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 10-01-19 JLM VERIFIED BY:EC IPP
Rev:B as per ECN10-571 DD 10.05.10 verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X06.00 0		Purchased			No	100	f	12.0000	0.96	5.052632			
M6061T6B0 500X06 000													
6061-T6 Bar .500 x 6.00													

Location

Loc Qty

Loc Code

MAT

12

M136697

12

3.67

DAS
44
9-89

17-02-25

**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

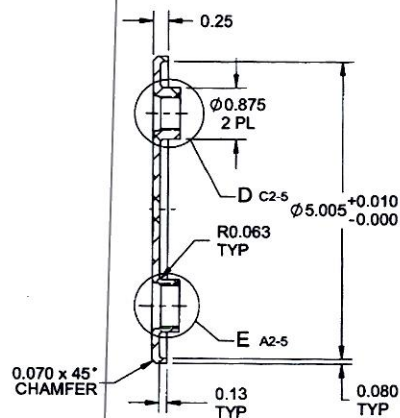
DART AEROSPACE LTD		Work Order:	156781
Description: Cap		Part Number:	D3262-5
Inspection Dwg: D3262	Rev: <i>F4</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

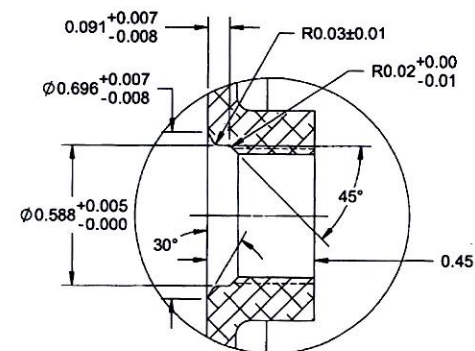
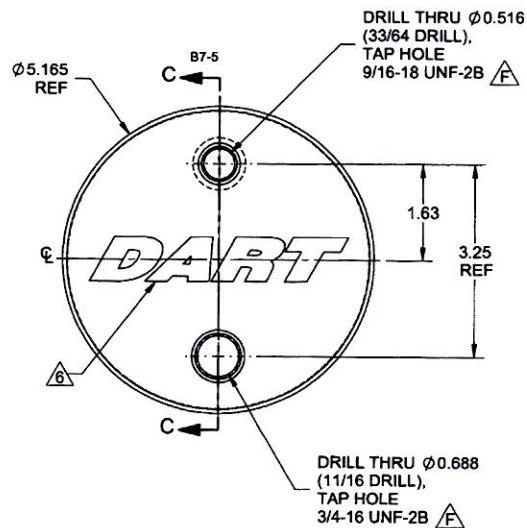
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.45	+/-0.030	.436	/		Vern	FK-01
0.25	+/-0.030	.247	/		"	"
Ø0.875	+/-0.010	.874	/		"	"
Ø5.005	+0.010/-0.000	5.006	/		"	"
R0.063	+/-0.010	.0625	/		R-G	
0.080	+/-0.010	.080	/		Vern	FK-01
0.13	+/-0.030	.125	/		"	"
0.070 x 45°	+/-0.010 x 0.5°	.065 x 45°	/		"	"
					"	"
Ø5.165 Ref	+/-0.010	5.164	/		"	"
1.63	+/-0.030	1.63	/		"	"
3.25 Ref	+/-0.030	3.25	/		"	"
9/16-18 UNF-3B	N/A	9/16-18	/		-	
3/4-16 UNF-3B	N/A	3/4-16	/		-	
0.091	+0.007/-0.008	.093	/		Vern	FK-04
R0.03	+/-0.010	.03	/		R-G	
R0.02	+0.00/-0.01	.02	/		"	
45°	+/-0.5°	45°	/		A-G	
30°	+/-0.5°	30°	/		"	
Ø0.588	+0.005/-0.000	.590	/		Vern	FK-04
Ø0.696	+0.007/-0.008	.696	/		"	"
0.101	+0.008/-0.007	.102	/		"	"
R0.03	+/-0.010	.03	/		R-G	
R0.02	+0.00/-0.01	.02	/		"	
45°	+/-0.5°	45°	/		A-G	
30°	+/-0.5°	30°	/		"	
Ø0.771	+0.005/-0.000	.772	/		Vern	FK-04
Ø0.882	+0.008/-0.007	.882	/		"	"

Measured by:	DAS 44 9-89	Audited by:	DAS 49 9-89	Preliminary Approval:	
Date:	17-02-26	Date:	17/02/27	Date:	

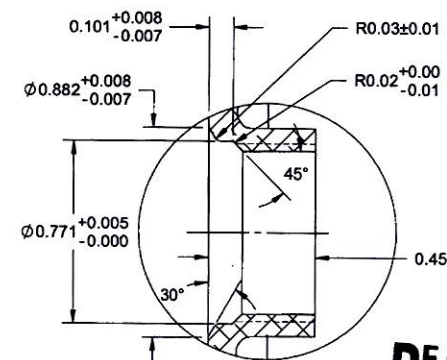
Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	<i>[Signature]</i>



SECTION C-C D5-5



DETAIL D SCALE 2X C7-5



DETAIL E SCALE 2X B7-5

**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER**

D3262-5 CAP

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.27 lbs

NO. 156781 M3
1702-08

RELEASED
2014-07-15

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. F
	MFG. APPR.	JLM	D3262	SHEET 5 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	FUEL PURGE CANISTER	NTS
DATE		14.06.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	